

SHIP APRIL 29

Work Order ID 143876

143876

Page 1

Thursday, March 24, 2016 2:37:23 PM

Item ID: D206-797-022

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Quick Release Heli-Utility-Basket™ RH 206L / L1 / L3 / L4 Heavy Duty Lid

Start Date: 4/18/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/27/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:

Process Plan: 

Date: 6-3-24

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D206-797-2	B

DAS
6
9-89

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD206-797-022 CHG005

DAS
6
9-89

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

****Mask label plate to size of D4307 label, use scotchbrite red pad to lightly sand area for label, apply label ****

APR 29 2016

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Memo

0.00

Quality Control

Inspect label on lid

DAS
9
9-89

① 16-05-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Thursday, March 24, 2016 2:37:23 PM

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Page 2

Item ID: D206-797-022

Accept

N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Quick Release Heli-Utility-Basket™ RH 206L / L1 / L3 / L4 Heavy Duty Lid

Start Date: 4/18/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/27/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC4- 100% Inspect kits for completeness 0.00

120

QC Memo 0.00

Quality Control

Smb
16/5/2

130 Pick Kit 0.00

130

Packaging Memo 0.00

Packaging Identify and pack for shipping as per PPP D206-797-022

Location: _____

PPP rev: _____

sold

Smb
16/5/2

140 QC21- Final Inspection - Work Order Release 0.00

140

QC Memo 0.00

Quality Control

MAY 02 2016

MLJ

Smb 16/05/02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
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Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : ☐					
Misidentified ☐	☐ Past Due						

Picklist Print

Thursday, March 24, 2016 2:37:30 PM

Page 1

Work Order ID: 143876

143876

Parent Item: D206-797-022

D206-797-022

Parent Item Name: Quick Release Heli-Utility-Basket™ RH 206L / L1 / L3 / L4 Heavy Duty Lid

Start Date: 4/18/2016

Required Date: 4/27/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.29 new issue DD verf:JLM IPP Rev:B
11.02.10 as per IIN rev.A DD verf:JLM IPP Rev:C 11.09.12 @
chg 002 DD verf:EC IPP REV:D 12.03.06 AS PER ECN12-
535 DD VERF:EC IPP REV:E 12.07.24 AS PER ECN12-611 DD
VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-797-211		Manufactured	No			110	Each	1.0000	1	1			
D206-797-211									**	<u>144822</u>		DAS 8 9-89	
Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG034		1							
				119447		1							
D4272-012		Manufactured	No			110	Each	0.0000	1	1			
D4272-012									**	<u>143871</u>			
Basket Assembly, Heavy Duty Lid, RH													

DAS
8
9-89

APR 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
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Past Expiry Date ☐	☐ Manufacturing Process	☐ OTHER : _____					
Misidentified ☐	☐ Past Due						